

Wednesday, 5/23/2007 3:25:13 PM
Ken Johnston

Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 32479-2
Estimate Number : 10774
P.O. Number : N/A
Date of Issue : 5/23/2007 S.O. No. : N/A
Revision : NC
Drawing Issue : N/A Type : LARGE FAB ASSY
Previous Run : 30306
Drawn By :
Checked & Approved By :
Comment : Est A 05.09.13 New issue K/JJLM

Drawing Name : LUG ASSEMBLY
Part Number : D3414041
Drawing Number : D3414 REV A
Project Number : N/A
Drawing Revision : A
Material : N/A
Due Date : 6/10/2007

Qty: 4 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M304S12GA 304/316 .100" Sheet.



Comment: Qty.: 0.1523 sf(s)/Unit Total: 3.0450 sf(s)

304/316 stainless steel 0.100" Sheet

Batch: M105130

SAD 07/07/25

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3414

Dwg Rev: 4

Prog Rev: A

SAD 07/07/25

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/07/25

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SAD 07/07/26

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr

Form using DT8254 as per Dwg D3414

FF 07-08-01 30

Process Sheet

Order: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Number: 32479

Part Number: D3414041

Number:



eq. #: Machine Or Operation: Description:

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 07/08/01 (425)

7.0

D34143

Lug



Comment: Qty: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Lug

Pick:

Qty

Part Number Description

Batch

1

D3414-3

Lug

A/R

SS Rod

~~B32516~~ B 33950
~~M102421~~ M102421

SS 07/09/04 (4)

SS 07/08/02 (11)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld using location Jig DT8484 as per Dwg D3414

SS 07/09/04 (4)
SS 07/08/02 (11)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

SS 07/09/04 (4)
SS 07/08/02 (11)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SS 07/09/04 (4)
SS 07/08/02 (11)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3

M105068 BR 07-09-04 M-L 07/08/07
PRESSURE WASH BR 07/08/07

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

P-7/15/8 (11)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

CD 07/09/04 (4)
52475 P-7/15/8 (11)

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Item: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 32479

Part Number: D3414041

Number:



Seq. #:

Machine Or Operation:

Description:

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(H)

Comment: FINAL INSPECTION/W/O RELEASE

Done 7/10/04

Job Completion

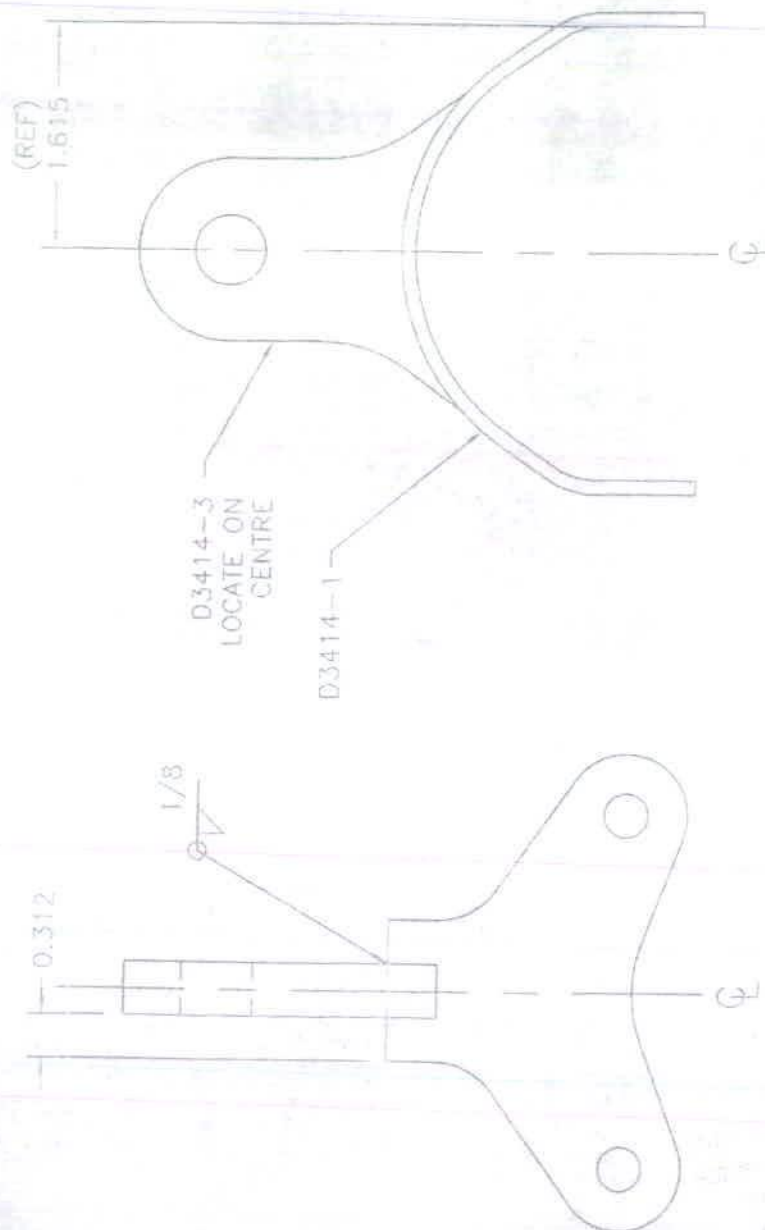


CL 7/10/08

CL 7/10/04

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3414	REV: A SHEET 1 OF 3
DATE 05.03.16		TITLE LUG ASSEMBLY	SCALE NTS
A	05.03.16	NEW ISSUE	

05.03.16 *[Signature]***D3414-041 LUG ASSEMBLY**

- 1) WELD PER DART OSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART OSI 005.4.3
- 3) TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRIC ABOUT CENTERLINE.

32479

